



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3319-7
Job Sheet 168822



Part No: D3319-7

Job Qty: 6 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/4/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-06-26 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/2/17	0.00	0.00	Start Up Waterjet		De
100	Waterjet	6 pcs		12/2/17	0.00	0.58	Waterjet1		De
110	QC	6 pcs		12/2/17	0.00	0.00	QC2		De DAS
120	QC	6 pcs		12/2/17	0.00	0.00	QC8		38
140	Brake NC	6 pcs		12/2/17	0.00	0.33	Brake NC 2		DAS 9-89
150	QC	6 pcs		12/2/17	0.00	0.00	QC6		38
160	Autoweld 1	6 pcs		12/4/17	0.00	0.86	Automated welding		9-89
170	QC	6 pcs		12/4/17	0.00	0.00	QC10		PD
180	QC	6 pcs		12/4/17	0.00	0.00	QC5		PD
190	HandFinish	6 pcs		12/4/17	0.00	0.00	HandFinish1		DEC 19 2017
200	QC	6 pcs		12/4/17	0.00	0.00	QC5		17-12-21
210	Packaging	6 pcs		12/4/17	0.00	0.00	Packaging3		DAS
220	QC21-SA	6 Ea		12/4/17	0.00	0.00	QC21		21 DEC 22 2017

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 140 - Form using DT8326 & DT8261 as per Dwg D3319 Rev: _____

160 - 8259 Hardcoat Rod M138629

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 138705

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-7, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S18GA	3	218	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190Inches	+ 0.005 - 0.001	0.195 0.189	
2	Wearplate	0.316Inches	+ 0.006 - 0.001	0.322 0.315	
3	Wearplate	0.607Inches	± 0.010	0.617 0.597	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			
Date : _____		Step #: _____		QTY Effective _____					
Description Work Order Deviation									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature/C ☐ Set-up ☐ BOM/Route ☐ Broken/Dam: ☐ Inspection In ☐ Contaminati ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/C ☐ Set-up ☐ BOM/Route ☐ Broken/Dam: ☐ Inspection In ☐ Contaminati ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wearplate Aft	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐								
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		D3319-7 Start up Operation		PART NO: Revision: Operation: Change No:		Mfg Date: 11/29/17 Job No: 168822			
		OTHER : _____							

4	Wearplate	0.600Inches ± 0.030	0.630 0.570
5	Wearplate	2.690Inches ± 0.010	2.700 2.680
6	Wearplate	3.526Inches ± 0.010	3.536 3.516
7	Wearplate	4.520Inches ± 0.030	4.550 4.490
8	Wearplate	5.063Inches ± 0.010	5.073 5.053
9	Wearplate	6.160Inches ± 0.030	6.190 6.130
10	Wearplate	11.650Inches ± 0.010	11.660 11.640
11	Wearplate	12.750Inches ± 0.030	12.780 12.720
12	Wearplate	0.048Inches ± 0.010	0.058 0.038
13	Wearplate	0.500Inches $+ 0.006$ $- 0.010$	0.506 0.490
14	Wearplate	0.504Inches ± 0.010	0.514 0.494

Plex 11/23/17 10:43 AM dart.poulin.mario

DQA: _____ Date: _____



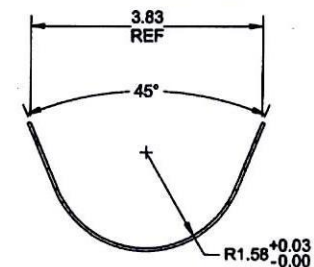
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

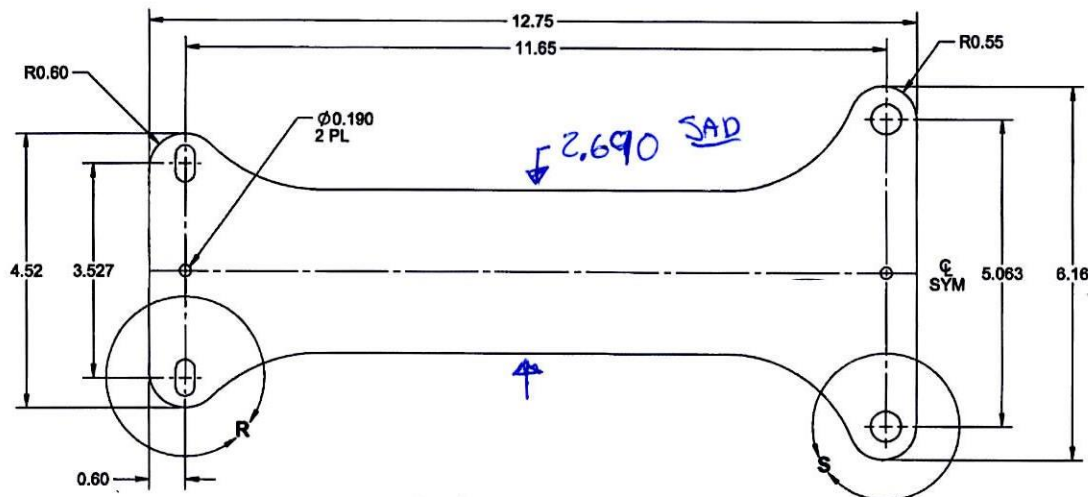
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

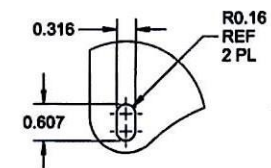
D3319-7BND WEARPLATE
MAKE FROM D3319-7F



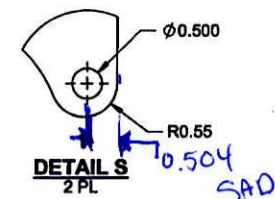
REFERENCE ONLY



D3319-7F WEARPLATE
FLAT PATTERN



DETAIL R
2 PL



DETAIL S
2 PL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.048 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR
ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.71 lbs
- 8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-7F-REV.D.XF

RELEASED

2017 AUG 19

APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DP	D3319	SHEET 8 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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